

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019789**Date Inspected:** 14-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A2-029

Weld No: 014,015,017,019,020

Welder: 040434

WPS-B-T-2232-ESAB

Heat straightening of PCMK, BK004A1-030 under approved Heat Straightening procedure, HSR1(B)-9865. The in process temperature was observed as 230°C. The ZPMC QC was identified as Li Ping Fei. The approved HSR procedure stated that a maximum temperature of 600°C with 1~3 numbers of applications was allowed. The

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distortion that was previously measured and recorded on the HSR was Maximum 20mm.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Li Yang, CWI Shi Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG12AE TO 12BE

PCMK: SP3001-001

Weld No: 081,082

Welder: 040320

WPS-B-P-2214-B-U2-Fen-1

Component; OBG12AE TO 12BE

PCMK: SP3002-001

Weld No: 091~197

Welder: 053871

WPS-B-P-2214-B-U2-Fen-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wong Li Yang, CWI Shi Lei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG12AE TO 12BE

PCMK: SEG3001A-001

Weld No: 004

Welder: 040458

WPS-B-T-2231-ESAB

Component; OBG12AE TO 12BE

PCMK: BP3001-004, T rib hold back area

Weld No: 060

Welder: 040458

WPS-B-T-2132-ESAB

Component; OBG12AE TO 12BE

PCMK: OBE12B-001

Weld No: 011

Welder: 047353

WPS-B-T-2231-ESAB

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This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG 11DW. The weld designations reviewed are as follows:

SSD22-PP104.5-001,002, SSD22-PP105.5-001,002, SSD22-PP106.5-001,002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
